

# Work Order ID 82564

April-03-12 8:34:54 AM

**\*82564\***

Page 1

Item ID: D2562-001

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Strut

Stop **\*NS2\***

Start Date: 03/04/2012 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 17/04/2012 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/03 Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2562

Rev D

100

0.00

**\*100\***

NC BRAKE

Brake NC

Memo

0.00

Brake NC

Punch to length as per Dwg D2562

10

~~10~~

FF  
12/04/10

110

0.00

**\*110\***

Small Fab

Small Fab

Memo

0.00

Small Fab

1- Bend end as per Dwg D2562 Angle "D"2-Deburr

10

~~10~~

FF  
12/04/10

120

QC5- Inspect part completeness to step on W/O

0.00

**\*120\***

QC

Memo

0.00

Quality Control

12/04/10

(10) ~~10~~

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 82564

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Page 2

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**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Strut

Start Date: 03/04/2012 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 17/04/2012 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

**\*130\***

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

M 121134

4:00 PM

11:10

11:40

10X

Ø

M 12/04/19

140

QC3- Inspect Part Finish

0.00

**\*140\***

QC

Memo

0.00

Quality Control

10

Ø

B 12/4/19

150

Identify as per dwg & Stock Location: 252

0.00

**\*150\***

Packaging

Memo

0.00

Packaging

10

12/4/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 82564**

April-03-12 8:34:54 AM

**\*82564\***

Page 3

Item ID: D2562-001

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Strut

Stop **\*NS2\***

Start Date: 03/04/2012 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 17/04/2012 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

Memo

0.00

Quality Control

12/4/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

April-03-12 8:34:58 AM

Page 1

Work Order ID: 82564

\*82564\*

Parent Item: D2562-001

\*D2562-001\*

Parent Item Name: Strut

Start Date: 03/04/2012

Required Date: 17/04/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP F02.04.15Added dwg Rev.B1 NG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.035		Purchased	No			100	f	227.3811	1.7067	17.96526			

**\*M304TR0 500W 035\***

304 RD Tube .500 x .035W

\*\*

10

FF  
12/04/18

Location

Loc Qty

Loc Code

MAT017

227.3810623

115535

0.913

116720

1.66068

117598

7.6415923

119160

4.79

119644

2.1209

120633

210.25489

17.96526

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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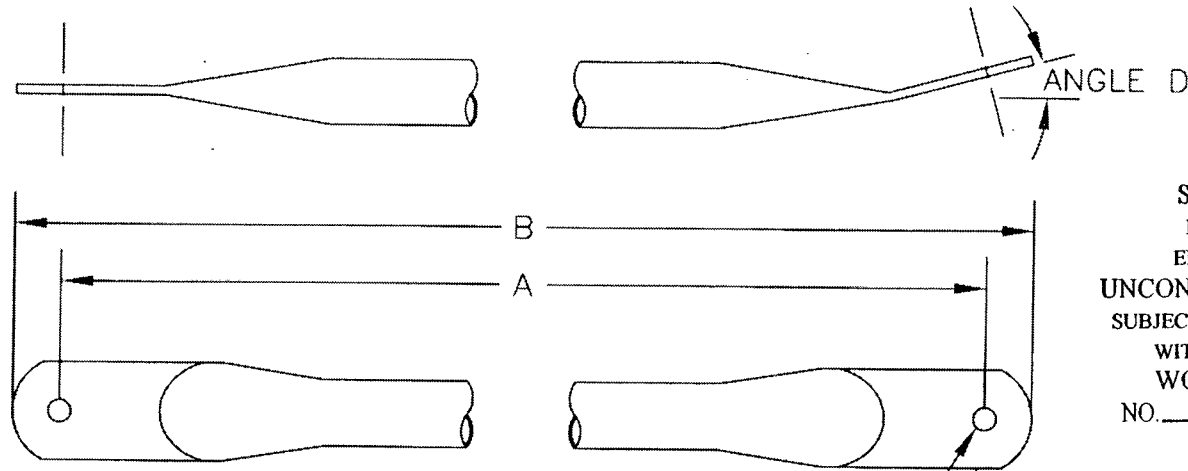
**NOTE:** Date & initial all entries





SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 82564 MLC

12/04/03



"C" DIA TO BE OPENED MANUALLY

PUNCH ENDS PER SPEC CONTROL DRAWING D2727

PART #	DIM A	DIM B	DIA C	ANG D
D2562-001	19.68	20.48	—	10
D2562-003	20.37	21.17	—	18
D2562-005	29.00	29.80	—	30
D2562-007	19.22	20.02	—	0
D2562-011	25.79	26.59	—	16
D2562-013	26.63	27.43	—	24

#### GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.500 OD X 0.035 WALL (REF DART SPEC. M304TR0.500W.035)  
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED  
05.05.27

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DESIGN	CP	DRAWN BY	RF	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	05.05.18	TITLE	D2562	REV. D
			STRUT	SHEET 1 OF 1
A		NEW ISSUE		SCALE
B		UPDATED MATERIAL NOTE (TSR A603)		1:2
C		ADD -005; ADD FINISH		
D		ADD -007/-011/-013; UPDATE -005		

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